

Please ensure that your Retread Plant Manager receives a copy of this bulletin and reviews it with all plant personnel.



TECHNICAL BULLETIN
Retreading of Super Single Casings

TB#10-02A

January 13, 2011

(Replaces Technical Bulletins TB#10-02)

To: Goodyear Authorized Retreaders

INTRODUCTION

This bulletin is to provide retreading information related to Super Single casings used for long haul service. The tire sizes affected by this bulletin are:

- 445/50R22.5
- 455/55R22.5

CASING REQUIREMENTS & SPECIFICATION:

It is recommended at this time to allow only one retread per casing for drive, trailer or dolly long haul applications.

- Only 1 Nail Hole Repair in a drive retread
- Only 2 Nail Hole Repairs in a trailer retread
- No Section Repairs

EQUIPMENT REQUIREMENTS

The width of the 445/50 and 455/55 tires exceeds the capability of most standard retread equipment. **Appropriate conversion kits / upgrades will need to be installed on some retread equipment. Appropriate upgrades can be obtained from your equipment supplier. Refer to attachment below.**

INITIAL INSPECTION REQUIREMENTS & SPECIFICATIONS:

Normal Initial Inspection following the guide lines in the Goodyear Authorized Retread Process Manual.

The NDT Probe needs to be 13 1/2” long – part #'s:

Hawkinson NDT..... part # H00-0729

Atec NDTpart # X-Probe

BUFFING REQUIREMENTS & SPECIFICATIONS:

It is recommended to use the 14 1/2” rim width for buffing.

Excessive shoulder wear:

After buffing the crown of the tire, any area of the shoulder that did not receive buffed texture can be:

- No more than 1/2” wide as measured from the edge of the shoulder inward.
- No more than 12” in total circumference per shoulder. For example, one spot 9” long in circumference and a second location no more than 3” long in circumference.

Be sure to hand buff non-texturized areas.

The shoulders of the Goodyear Super Single tires contain fabric belt strips covering the ends of the steel belts. If these should be exposed, the fabric should be treated as an ECD top belt. The fabric should be removed back tight to the rubber to prevent poor bonding between the cushion and the casing (see photo at the end of this bulletin).

C-Hooks need to be at least 16 1/4” wide or use two regular C-Hooks. **(Two hooks will not work on rubber sure seals)**

Buffer Programs:

Prog #	Tire Size &	Precure	Tire Dia. D	Trd Width W1	Buff Rad R1	Carr"Z" W2	Shd Rad. R2	SW L	SW ang A	Stl Belt S	SW Brush SB	Rim Width
900	445/50R22.5	15 1/4	38 13/32	15 1/4	84	9	0	1/32	35	6/32	2	14 1/2
901	455/55R22.5	15 7/8	40 13/32	15 7/8	80	9 3/4	0	1/32	35	6/32	2	14 1/2

CUSHION GUM REQUIREMENTS & SPECIFICATIONS:

- o AZ Extruder needs to extrude up to 15 7/8” wide.
- o The AZ SB-V and AZ SB-VII are the two AZ Extruders that are capable of 15 7/8”
- o If you have an AZ SB-II it is suggested that you use Calendar Cushion Gum

CALENDERED CUSHION PRODUCT CODE

702-010-266 15 3/4” calendared cushion gum

702-010-280 17” calendared cushion gum

BUILDING REQUIREMENTS & SPECIFICATIONS:

- It is recommended to use the 14 ½” rim width as standard.
- Add 1.2” Cushion Gum to both shoulders after applying AZ cushion or calendar cushion gum
- Insure that the wick pad is long enough to extend past each shoulder into the upper sidewall.

CURING REQUIREMENTS & SPECIFICATIONS:

4515 Curing Envelope size will fit both the 445/50R22.5 & the 455/55R22.5 casings.

FINAL INSPECTION REQUIREMENTS & SPECIFICATIONS:

Use Shorter spacers from Central Marketing for the 445/ 50 and 455/55 tire sizes.
Part # PM-52TTZ12445

EQUIPMENT REQUIRED TO RETREAD SUPER SINGLE TIRES

BUFFING

Customer: GOODYEAR TIRE & RUBBER CO.

QTY	DESCRIPTION
Each	Wide Tire Buffing Kit for RAS 90DC Buffers #G1 through G17 (30 HP machines), to include: <ul style="list-style-type: none">⌚ pivot motor⌚ overload protection⌚ inverter⌚ cables⌚ e-prom for PLC⌚ software Revision M06⌚ wide convex rasp⌚ pair of steel backing plate hubs
Each	Wide Tire Buffing Kit for RAS 90DC Buffers #G18 and up (40 HP machines), to include: <ul style="list-style-type: none">⌚ wide convex rasp⌚ software Revision M06⌚ pair of steel backing plate hubs
Each	Wide Tire Buffing Kit for RAS 98-E Buffers, to include: <ul style="list-style-type: none">⌚ wide convex rasp⌚ software Revision M06 <p><i>(NOTE: You will also need to purchase an expandable rim, price not included in this quotation)</i></p>
Each	RAS 90 Ultra and RAS 98-E Ultra Buffers are already capable of retreading these tires. Nothing additional is needed.

BUILDING

QTY	DESCRIPTION	COMMENTS
Each	AZ Cushion Extruder SBII – to do these tires, the extruder head needs to be replaced. We suggest you use calendar cushion or consider trading in the machine for the SB VII model.	N/A
Each	AZ SB V – capable of running these tires. Nothing additional is needed.	N/A
Each	AZ SB VII – capable of running these tires. Nothing additional is needed.	N/A
Each	Matteuzzi RAS 505 Builder	The cost to redo this machine is cost prohibitive
Each	Matteuzzi RAS 500 Builder	The cost to redo this machine is cost prohibitive
Each	Matteuzzi RAS 401 Builder	The cost to redo this machine is cost prohibitive
Each	Matteuzzi RAS 201 Builder – is already capable of running these tires. Nothing additional is needed.	N/A
Each	Matteuzzi RAS 405 Builder – is already capable of running these tires. Nothing additional is needed.	N/A

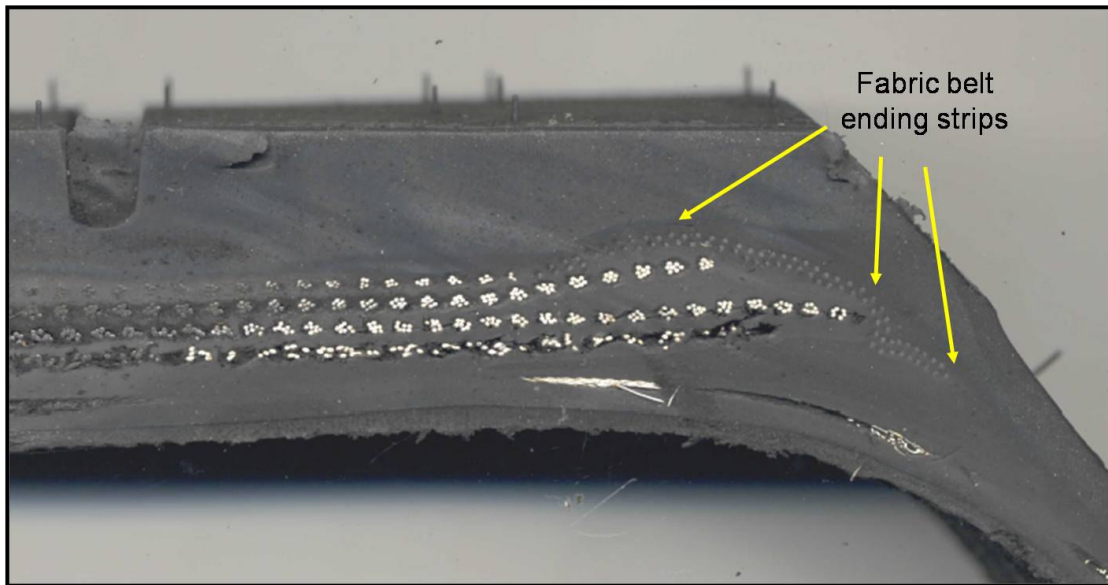
ENVELOPING

QTY	DESCRIPTION
Each	Matteuzzi Enveloper – is already capable of running these tires. Nothing additional is needed.
Each	Wide Sure-lock table

SHEAROGRAPHY

QTY	DESCRIPTION
Each	Steinbichler Shearography Machines – are already capable of running these tires. Nothing additional is needed.

FABRIC BELT STRIPS



Cross section of G394

**Approved By
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